

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008285**Date Inspected:** 11-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia and Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

3AE

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 3AE PP22. The weld designations reviewed are as follows:

1. SSD18A-PP22-004/005

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as OBG 3AE PP22. The weld designations reviewed are as follows:

1. SSD18A-PP22-004/005

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### 1AAW & 1AW

FCAW welding of weld joint 050 located on SEG004B.

Welder is identified as Mr. Yun Chuanshan (050316). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U3-F.

FCAW welding of weld joint 050 located on SEG004C.

Welder is identified as Mr. Li Mingyang (045280). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U3-F.

FCAW welding of weld joints 565~559 located on SEG2E.

Welder is identified as Mr. Jiang Yafei (045276). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U3-F.

FCAW welding of weld joints 558~553 located on SEG2E.

Welder is identified as Mr. Ji Hongwei (058245). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U3-F.

SMAW welding of weld joint 004 located on OBW1A.

Welder is identified as Mr. Zhang Xiaochong (220068). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1.

SMAW welding of weld joint 002 located on OBW1A.

Welder is identified as Mr. Du Hengyou (037743). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1.

SMAW welding of weld joint 003 located on OBW1A.

Welder is identified as Mr. Qie Jianzhou (067571). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1.

### 1AAE & 1AE

FCAW welding of weld joint 002 located on OBE1.

Welder is identified as Mr. Li Mingyang (045280). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2213-B-U2-FCM.

SMAW welding of weld joint 004 located on OBE1A.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1.

SMAW welding of weld joint 003 located on OBE1A.

Welder is identified as Mr. Tian Zhaoquan (045246). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1.

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SMAW welding of weld joint 003 located on OBE1.

Welder is identified as Mr. Liu Houkuan (045133). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-U2-FCM.

1AAW

SMAW welding of weld joints 889~877 located on SEG2E.

Welder is identified as Mr. Hao Jianxiang (067665). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-FCM-1.

SMAW welding of weld joints 848~836 located on SEG2E.

Welder is identified as Mr. Li Jian (067829). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for

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your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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